

Work Order ID 75843

75843

Page 1

Friday, November 18, 2011 10:26:38 AM

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/11/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
DSI 9583	A	*SP*
K10111	B	

100 DOCUMENT CONTROL 0.00
100
 DC Memo 0.00
 Document Control Photocopy bluefile & type labels per PPP K10111 CHG003 *Size 10/10*
 FOR D206-642-111 CHG007
 FOR D206-642-113 CHG002

HA for MLI 12-2-9
(4)

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging

SP 12-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75843

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75843


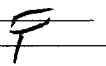

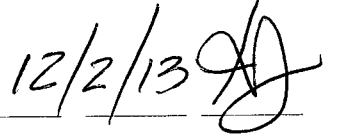
Page 2

Item ID: * K10111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/11/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		8/17/11					
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP PPP D206-642-111 PPP D206-642-113 Location: _____ PPP rev: 	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12-02-10
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75843

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A		Purchased	No				Each	872.0000		16			
AN5-10A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST337				872					
				116704				11					
				118191				59					
				119547				802					
AN5-11A		Purchased	No				Each	1,599.000		16			
AN5-11A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST337				21					
				117313				2					
				118191				19					
				ST518				1578					
				119512				1578					
AN3-41A		Purchased	No			110	Each	1,655.000	8	32			
AN3-41A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st510				1655					
				119042				1655					

SP

160x

SP

160x

SP 12-02-09

32x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75843

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No 110 Each 5,062.000 12 48

AN4-6A

Bolt

**

SP

Location Loc Qty Loc Code

ST356 62

119127 62

ST516 5000

119017 5000

48x

AN4C5A Purchased No 110 Each 489.0000 1 4

AN4C5A

BOLT

**

SP

Location Loc Qty Loc Code

FP-B 49

112243 49

ST355 440

112243 340

119017 100

4x

AN6-44A Purchased No 110 Each 511.0000 2 8

AN6-44A

Bolt

**

SP

Location Loc Qty Loc Code

ST343 7

119127 7

st510 504

119036 504

8x

D206-651-041 Manufactured No 110 Each 1.0000 1 4

D206-651-041

206A/B GHW

**

B77866 SP

Location Loc Qty Loc Code

FG125 1

74002 1

4x

12-02-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2652- Manufactured No

110 Each 743.0000 16 64

D2652

Bushing

**

B77035 SP

Location

Loc Qty

Loc Code

FG	44
31985	44
ST019	699
73835	579
73836	120

D2661-1 Manufactured No

110 Each 18.0000 2 8

D2661-1

Saddle, LH Fwd Aft Out 206

**

B78136 SP

Location

Loc Qty

Loc Code

MEZZ	5
64559	5
ST435	13
73838	10
73841	1
76516	2

D2662-1 Manufactured No

110 Each 20.0000 2 8

D2662-1

Saddle, LH In 206

**

B78150 21

B78148 4x

B78152 2x

Location

Loc Qty

Loc Code

ST435	10
73846	1
74479	9
ST476	10
74481	10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2712 Manufactured No 110 Each 2,551.000 10 40

D2712

Set Screw

**

SP.

Location

Loc Qty

Loc Code

FG 50

29962 50

ST021 2501

71160 1

73837 500

76065 2000

D2884 Manufactured No 110 Each 100.0000 2 8

D2884

Saddle Spacer

**

B76751 SP.

Location

Loc Qty

Loc Code

FG 10

29453 10

ST025 90

73823 90

D2885 Manufactured No 110 Each 126.0000 2 8

D2885

Saddle Spacer

**

B76752 SP

12-02-09

Location

Loc Qty

Loc Code

FG 10

29199 10

ST025 116

73824 116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1 Manufactured No

110 Each 94.0000 1 4

D3413-1

Ring

**

B76754 SP.

Location Loc Qty Loc Code

ST368 2

73821 2

ST420 2

66387 1

70773 1

ST469 88

73822 88

ST473 2

71041 2

MS21042L3 / Purchased No

110 Each 8,753.000 8 32

MS21042L3

Nut

**

SP. 12-02-09

Location Loc Qty Loc Code

ST300 255

117441 16

117885 35

118451 5

118927 199

ST516 6000

119017 6000

ST518 2498

119075 2498

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,450.00

12

48

MS21042L 4

**

SP.

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

18x

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

MS21042L 6

**

SP.

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

8x

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

NAS1149C0463R

**

SP 12-02-09

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8

32

NAS1149D0363.I

Washer

**

m/20308 SP.

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24

96

NAS1149D0463.I

Washer

**

SP 12-02-09.

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119025

10000

119097

2258

96x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J Purchased No

110 Each 5,121.000 8 32

NAS1149D0563.I

Washer

** SP

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

32x

NAS1149D0663J Purchased No

110 Each 2,598.000 4 16

NAS1149D0663.I

Washer

** SP 12-02-09

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

16x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO. REV. C K10111 SHEET 1 OF 1	
MFG. APPR.	<i>BE</i>		
APPROVED	<i>140</i>	TITLE SCALE SADDLE KIT NTS	
DE APPR.	<i>140</i>		
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	